

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment. To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 or Figure 2 only. It is NOT acceptable to apply Armor Shield in the cuff and support/clamp regions. The following installations are applicable:

INSTALLATION	STC		CURRENT CHANGE NUMBER
	CANADIAN	FAA	
D205-596-101A/-103A/-105A/-107A	SH03-6 ISSUE 3	SR01742NY	CHG 002 (or later)
D212-664-101A/-201A			CHG 003 (or later)
D412-664-203A			CHG 005 (or later)
D212-664-107A/-207A	SH01-9 ISSUE 3	SR01298NY	CHG 001 (or later)
D412-664-105A/-205A/-209A			CHG 001 (or later)
D206-667-101A/-103A/-201A/-203A	SH01-5 ISSUE 3	SR01304NY	CHG 002 (or later)
D407-667-105A/-205A			CHG 003 (or later)
D058-676-101A/-201A	N/A	SR01018SE	CHG 002 (or later)
D350-748-101A/-201A	SH06-27 ISSUE 1	SR02359NY	CHG 001 (or later)

1.0 TO APPLY ARMOR SHIELD

- 1.1 Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 1.2 Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 1.3 Mask areas around supports and cuffs per Figure 1 or Figure 2 (D350-748-101/-201 only). Abrade paint finish in areas requiring protection using 800 grit sandpaper. Ensure the surface is de-glossed.
- 1.4 Re-clean the surface per Step 1.2.
- 1.5 Mix BCG4 Component A and BCG4 Component B in accordance with manufacturer's instructions.
- 1.6 Apply 5 wet coats in accordance with manufacturer's instructions.
- 1.7 To avoid hard tape line, unmask immediately after application of last coat.
- 1.8 Allow BCG4 to dry in accordance with manufacturer's instructions.

2.0 ARMOR SHIELD REMOVAL / RE-APPLICATION

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 2.1 Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2.2 Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 2.3 Apply Armor Shield in accordance with Section 1.0 of these instructions.

* Note that crosstubes with a change number prior to those listed in the above table used a Proform PF746/746-1 treatment, which has been discontinued. The current BCG4 treatment should be used for any re-application of the armor coat. The two treatments have a different surface texture and, at the operator's discretion, it may be preferential to completely re-finish the crosstube rather than touch up the discontinued armor coating.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED  BY: _____ D. SHEPHERD (DE # 02)
DATE: _____ 08.01.12 CERT. NO.: SEE TABLE ISSUE NO.: SEE TABLE

C	ADD D212-664-107A/-207A & D412-664-209A, REWRITE			CP	08.01.08
B	BCG4 REPLACES DISCONTINUED PROFORM PF 746 OR PF 746-1; ADD D350-748-101/-201			MB	07.10.17
A	NEW ISSUE			PH	06.02.14
REV.	DESCRIPTION			BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	<i>g</i>				
CHECKED	<i>CE</i>	DRAWING NO.			REV. C
MFG. APPR.	N/A	DSI 9326			SHEET 1 OF 2
APPROVED	<i>DP</i>	TITLE			SCALE
DE APPR.	<i>H</i>	ARMOR SHIELD			NTS
DATE	08.01.08				

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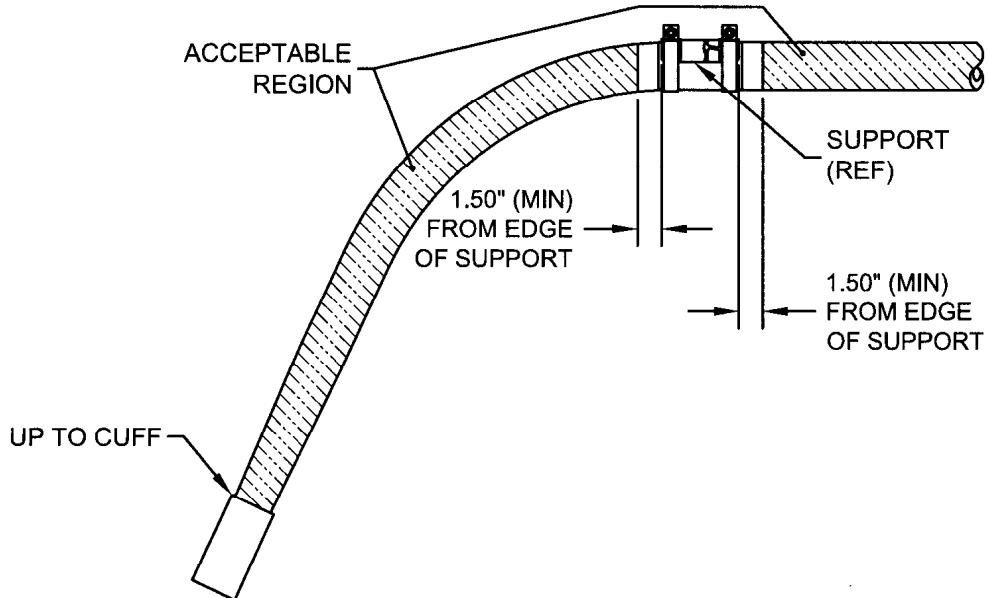


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD
(SEE FIGURE 2 FOR D350-748-101/-201 CROSSTUBES)

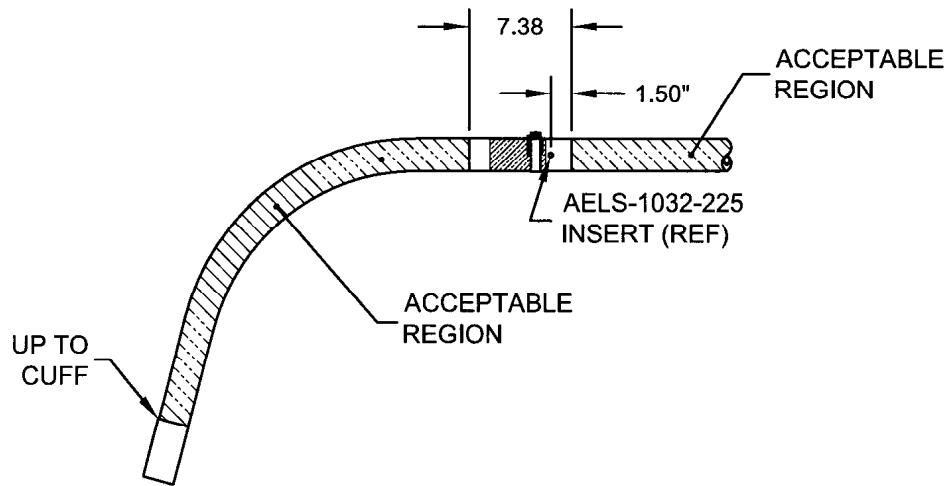


FIGURE 2 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD
(D350-748-101/-201 ONLY)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
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CERT. NO.:	SEE TABLE
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DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PP	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	REV. C	
APPROVED	NP	DSI 9326	
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